

slip 28/06

Work Order ID 85540

85540

Page 1

June-11-12 9:53:55 AM

Item ID: D119-646-243

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3905	B
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D3905-045,-13	B
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IIN-D119-646	B
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100 0.00

100

DC Memo 0.00

Document Control Photocopy bluefile & type labels per PPP D119-646-243
CHG 001

N/A

110 0.00

110

Skidtubes Memo 0.00

Skidtubes 1- Inspect Mat'l D2500-1-190 for damage

2- Ensure squareness of ends

De 12/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill								
	2- Scribe batch # inside aft end of tube								

1 7/16 12-6-12

① Ø DC 12/06/13

DC 12/06/13

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

0.00

155

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end.

2- Esure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

DE 12/06/14

165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Quality Control

Memo

0.00

DP 12-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Plan:

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

1- Verify dimention of bend as per dwg D3905

2- Buff out marks left from bending.

3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, open to finished size

4- Drill Aft wearplate and wearpad holes using DT9546 and DT9545 as per dwg D3905 detail G open to finished size

5- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E)
DO NOT OPEN FWD SADDLE HOLES

6- Deburr, blow out chips from inside of tube

7-Bond web in place as per Dwg D3905 & QSI 015.

A/R Sikaflex-291 12/409Sikaflex expire date: 13-4-12Start: 12/06/18Time: 9:20Finish: 12-06-20Time: 11:00

***** (Adhere for 12 hours) *****

DC 12/06/18

DC 12/06/18

- DC 12/06/18

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 QC5- Inspect part completeness to step on W/O 0.00

190

QC Memo 0.00

Quality Control

DP 12-6-19

200 0.00

200

CNC Bend 1 Memo 0.00

CNC Delta 100 Bender

1- Bend Fwd end of tube using bender 1 and bend prog. D3905 Fwd. Use bending aid DT9544 ensure proper positioning

2- Cut Fwd end of tube as per dwg.

VERIFY MEASUREMENT BEFORE CUTTING

DC 12/06/19

W/O:		WORK ORDER CHANGES					
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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

0.00

210

Skidtubes

Skidtubes

Memo

0.00

~~/~~ Buff out marks left from bending~~/~~ Drill Fwd cap holes using DT8215. Open Fwd and Aft cap holes to 0.208"~~/~~ Open Fwd saddle holes to finished size as per dwg~~/~~ Drill Fwd x-bolt hole and open to finished size. (Holes must be laid out manually)~~/~~ Drill trowing hole and open to finished size. (Holes must be laid out manually)~~/~~ Open Aft float holes 0.391" as per dwg D3905 detail G and section F-F~~/~~ Deburr, blow out chips from inside of tube.

1 0 CF 12/6/20

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Quality Control

Memo

0.00

1 0 BE 12/6/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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224

0.00

224

Skidtubes

Memo

0.00

1- Countersink x-bolt holes as per dwg

2- Remove alodine prepare for welding

3- Insert x-bolt spacers

4- Weld x-bolt spacer as per dwg

A/R Alum rod Batch: M12064

5- Grind welds flush as per dwg

6- Counter bore x-bolt holes as per dwg

7- Deburr

> CF 12-6-20

> BE 12-06-20

-> CF 12-6-21

> BE 12-06-21

225

QC5- Inspect part completeness to step on W/O

0.00

225

QC

Memo

0.00

Quality Control

1 M 12-06-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID Operation Description Set Up/ Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

226 QC10- Inspect visual per QSI004- ground welds 0.00

226

QC Memo 0.00

Quality Control

227 Pressure Wash per QSI005 4.3 0.00

227

HandFinish Memo 0.00

Hand Finishing

240 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

240

Powdercoat Memo 0.00

Powder Coating

11/20/2012

10:40
300°
11:10.

QC 120622

1 26 12-6-22

1 0 12-6-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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June-11-12 9:53:55 AM

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

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245 QC3- Inspect Part Finish

0.00

245

QC Memo

0.00

Quality Control

250	0.00
-----	------

250

HandFinish Memo

0.00

Hand Finishing 1-Install inserts as per Dwg D3905.

260	QC5- Inspect part completeness to step on W/O	0.00
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260

QC Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Item Name: Replacement Float Skidtube w/ Training Wearplates

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00

270

HandFinish

Hand Finishing

Memo

0.00

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers
A/RSikaflex-240/-291 121 404
Sikaflex expire date: 13/07

2- install plugs assembly as per dwg.

3 -Inspect for foreign objects as per QSI 024

4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
A/RSikaflex-240/-291 121 404
Sikaflex expire date: 13/07

1 2 12/06/2012

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Quality Control

Memo

0.00

5/10/03

W/O:		WORK ORDER CHANGES					
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285 Wing Walk as per dwg QSI005 4.4 Batch 121 123 0.00

285

HandFinish

Memo

0.00

Hand Finishing

1 2 28 12/06/29.

286 QC3- Inspect Part Finish 0.00

286

QC

Memo

0.00

Quality Control

ik 12-7-13.

290 Identify as per dwg & Stock Location: _____ 0.00

290

Packaging

Memo

0.00

Packaging

170 87090

12/11/13

Dart Aerospace Ltd

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

12/7/18 
mf
12-07-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-11-12 9:53:59 AM

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Parent Item: D119-646-243

D119-646-243

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190 *D2500-1-190* Ext'n -1' Beam Tube 4"		Manufactured	No			110	Each	85.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				HALL				85					
				74777				12					
				80061				73					
D3885-3 *D3885-3* Standard Web *		Manufactured	No			170	Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				LG				10					
				52425				10					
D3903-1 *D3903-1* Spacer		Manufactured	No			190	Each	70.0000	12	12			
				<u>Location</u>				<u>Loc Qty</u>					
				LG				40					
				74876				40					
				LG001				30					
				78790				30					

**

De 12/06/12

**

De 12/06/18

**

De 12/06/20

12

W/O:		WORK ORDER CHANGES					
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Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3681-1

Manufactured No

190

Each

53.0000

8

8

D3681-1

Spacer

BE 12/06/20

Location

Loc Qty

Loc Code

LG

43

80361

1

84053

42

B

LG001

10

68958

2

69893

2

71845

2

74874

1

76004

1

77501

2

D3683-3

Purchased

No

250

Each

586.0000

12

12

D3683-3

Insert

12

28

12/06/26

Location

Loc Qty

Loc Code

FP002

26

47805

26

ST060

560

47805 ✓

560

NO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-11-12 9:53:59 AM

Page

Work Order ID: 85540

85540

Parent Item: D119-646-243

D119-646-243

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

1,973.000

10

10

AI S4-1032-130

Insert

10

2P

12/06/26

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

44

120807

36

120837

8

ST282

1724

121269 ✓

1724

D2855-3

Manufactured

No

270

Each

22.0000

2

2

D2855-3

Cap

2

2P

12/06/26

Location

Loc Qty

Loc Code

FP002

22

52281

7

75080 ✓

15

D3672-1

Manufactured

No

270

Each

1,530.000

4

4

D3672-1

Phenolic Washer

4

2P

12/06/26

Location

Loc Qty

Loc Code

ST060

1530

72229

4

76277

20

80369 ✓

496

83608

500

85222

510

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-11-12 9:53:59 AM

Work Order ID: 85540

Parent Item: D119-646-243

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

85540

D119-646-243

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3849-045

Manufactured No

85342✓

270

Each

0.0000

1

1

D3849-045

AFT WEARPLATE ASSY, FLOAT GEAR

D3904-1

Manufactured No

270

Each

177.0000

16

16

D3904-1

Washer

**

1 (2P) 12/06/29

**

16 (2P) 12/06/26

Location

Loc Qty

Loc Code

ST068

177

51875✓

177

D3672-3

Manufactured No

270

Each

583.0000

12

12

D3672-3

Phenolic Washer

**

12 (2P) 12/06/26

Location

Loc Qty

Loc Code

ST060

583

84361✓

583

AN3C5A

Purchased No

270

Each

1,274.000

14

14

AN3C5A

Bolt

**

14 (2P) 12/06/26

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1267

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255✓

500

121444

154

121708

500

June-11-12 9:53:59 AM

Shop Packet Print

Page 5

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-11-12 9:53:59 AM

Work Order ID: 85540

Parent Item: D119-646-243

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

85540

D119-646-243

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

270

Each

43.0000

4

4

AN3C46A

BOLT

**

4

(2P)

12/06/2012

Location

Loc Qty

Loc Code

ST355

43

120447✓

43

AN960C10L

4

NAS1149C0332✓

Purchased

No

270

Each

21.0000

10

10 14

*AN960C10I *

washer

122063✓

**

14

(2P)

12/06/2012

Location

Loc Qty

Loc Code

ST

21

107534

21

AN960C416

*

NAS1149C0463✓

Purchased

No

270

Each

0.0000

12

12

AN960C416

washer

**

12

(2P)

12/06/2012

MS21043-3

Purchased

No

270

Each

1,439.000

8

8

MS21043-3

Nut

119097✓

**

8

(2P)

12/06/2012

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1367

118077

2

118614

51

118686

30

119758

20

121255

270

121708✓

994

June-11-12 9:53:59 AM

Shop Packet Print

Page 6

WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-11-12 9:53:59 AM

Work Order ID: 85540

Parent Item: D119-646-243

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

85540

D119-646-243

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039C4-08

Purchased

No

270

Each

98.0000

12

12

MS27039C4-08

SCREW

**

12

(2P)

12/06/26

Location

Loc Qty

Loc Code

FP002

7

17831

7

ST293

91

114721✓

91

AN3C50A

Purchased

No

270

Each

78.0000

4

4

AN3C50A

Bolt

**

4

(2P)

12/06/26

Location

Loc Qty

Loc Code

ST355

78

112761

20

114442✓

33

120447

25

D3411-3

Manufactured

No

270

Each

58.0000

16

16

D3411-3

WASHER

**

16

(2P)

12/06/26

Location

Loc Qty

Loc Code

ST042

58

51635✓

17

55317✓

41

WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

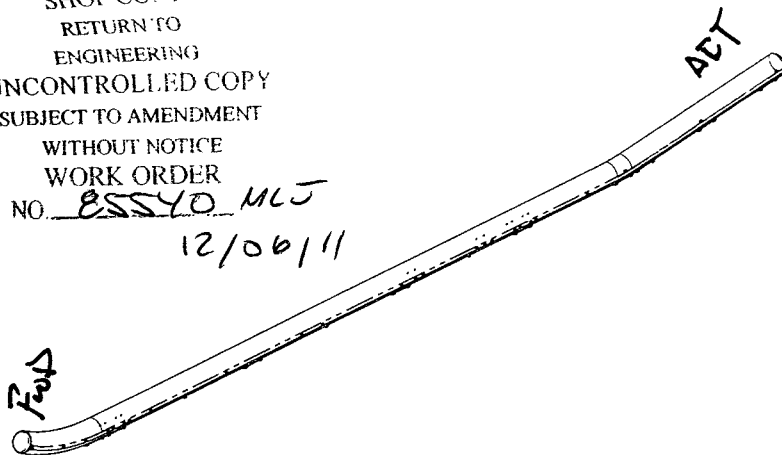
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85540 MLJ

12/06/11



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB
POWDER COAT "WHITE" (4.3 5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs
D3905-043 = 47.0 lbs
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT
PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE
WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO ϕ 0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL ϕ 0.297 HOLES FOR WEARPLATE INSERTS.
INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS
WITH SIKAFLEX-241/291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

RELEASED
09/06/11

REVISED PART LIST: ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A8-6, C5-7, C1-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2855 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); ϕ 0.313 WAS ϕ 0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8); REVISED NOTE N (ZN A8-7)		RF	09.06.30
NEW ISSUE		RF	09.03.30
DESIGN	RF	DESCRIPTION	
DRAWN	RF	DART AEROSPACE USA, INC.	
CHECKED	RF	PORT HADLOCK, WA	
MFG. APPR.	RF	DRAWING NO	
APPROVED	RF	D3905	
DE APPR	RF	TITLE	
DATE	09.06.30	A119 FLOAT SKIDTUBE ASSY	
		REV. B	SHEET 1 OF 8
		SCALE	NTS

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WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

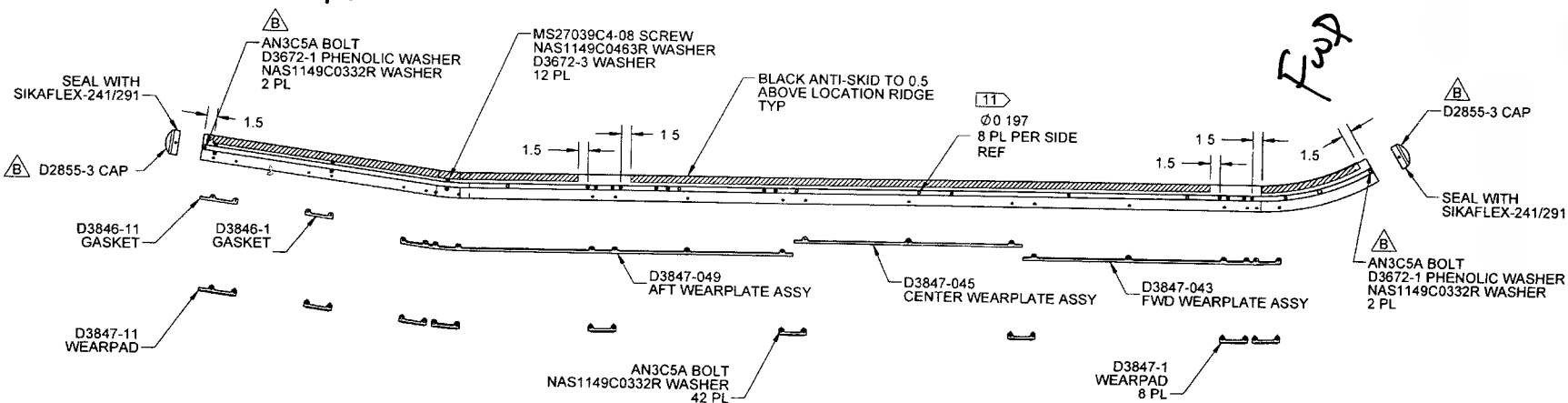
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE
(MAKE FROM D3905-11 SKIDTUBE)

RELEASED
21/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO	REV. B
MFG. APPR	RF	D3905	SHEET 3 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR	RF	A119 FLOAT SKIDTUBE ASSY	NTS
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WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

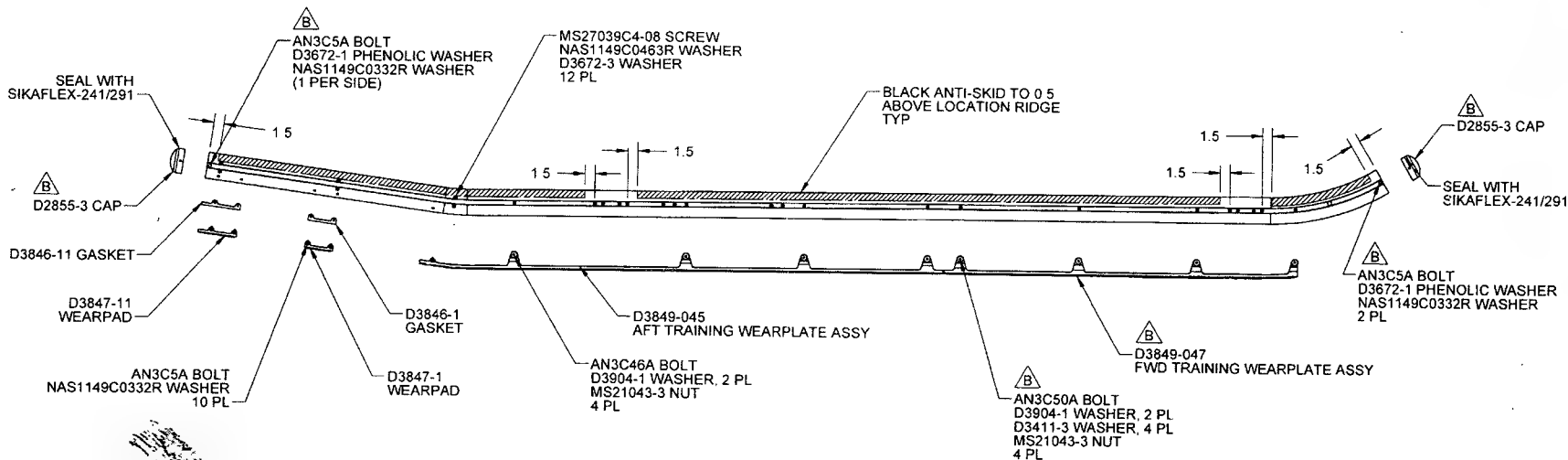
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3905-13 SKIDTUBE)

RELEASED
07/07/15 MAB

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 4 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR	RF	A119 FLOAT SKIDTUBE ASSY	NTS
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WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

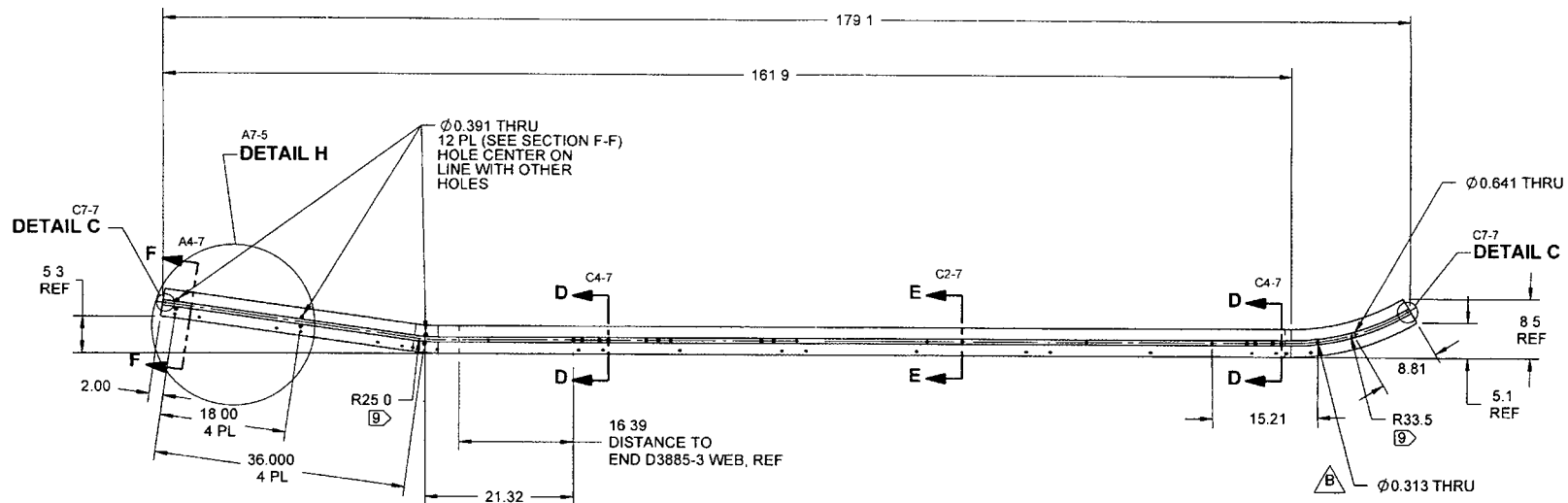
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NCR:

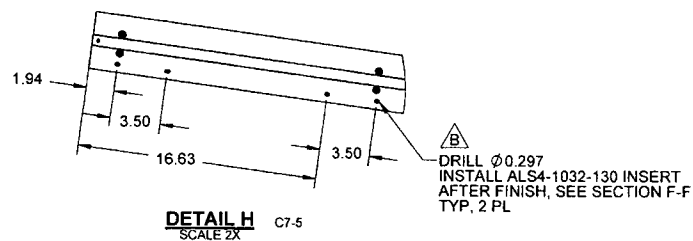
WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3905-11 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)



RELEASED
10/17/1971

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO	REV. B
MFG. APPR.	RF	D3905	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
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WORK ORDER CHANGES

/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL G

DETAIL C

5.3
REF

2.00

18.00

4 PL

36.00

4 PL

R25.0

21.32

16.39

DISTANCE TO

END D3885-3 WEB, REF

179.1

161.9

Ø0.391 THRU
12 PL (SEE SECTION F-F)
HOLE CENTER ON
LINE WITH OTHER
HOLES

D C4-7

D

E C2-7

E

D C4-7

D

15.21

Ø0.641 THRU

DETAIL C

8.5

REF

8.81

5.1

REF

R33.5

Ø0.313 THRU

D3905-13 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

1.94

3.50

14.70

3.50

32.89

DETAIL G
SCALE 2X

C8-6

B

DRILL Ø0.297
INSTALL ALS4-1032-130 INSERT
AFTER FINISH. SEE SECTION F-F
TYP, 2 PL

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO	REV. B
MFG. APPR.		D3905	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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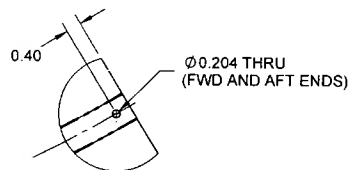
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

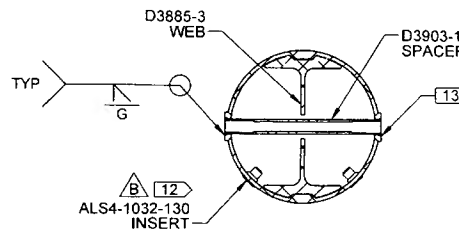
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL C
SCALE 4X

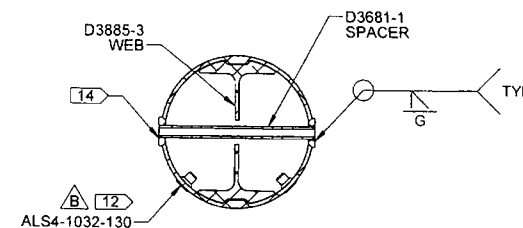
C1-5
C8-5
C8-6
C1-6



SECTION D-D
SCALE 4X

(FOR 12 x $\phi 0.375$ HOLES
PER SKIDTUBE)

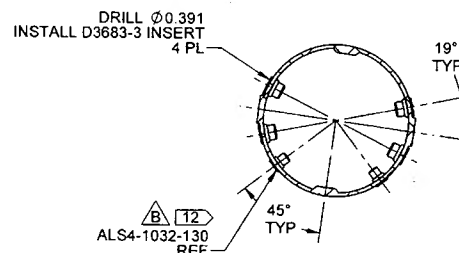
C5-5
C2-5
C5-6
C2-6



SECTION E-E
SCALE 4X

(FOR 8 x $\phi 0.313$ HOLES
PER SKIDTUBE)

C4-5
C4-6



SECTION F-F
SCALE 4X

C7-6
C7-5

NOTES:

- 13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:
i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$ (BOTH SIDES)
ii) INSERT D3903-1 SPACER
iii) WELD INTO PLACE AND GRIND FLUSH
iv) C'BORE TO 0.313×0.75 DEEP
v) DEBURR HOLES



- 14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.313$ HOLES ONLY:
vi) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
vii) INSERT D3681-1 SPACER
viii) WELD INTO PLACE AND GRIND FLUSH
ix) DEBURR HOLES

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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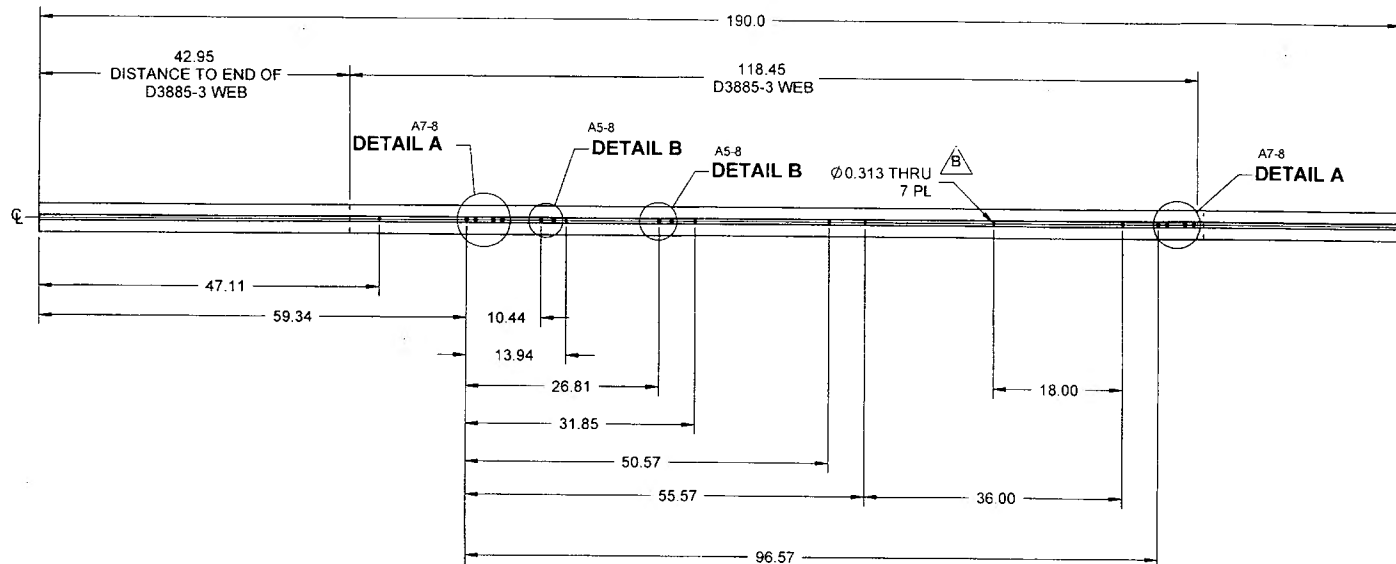
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

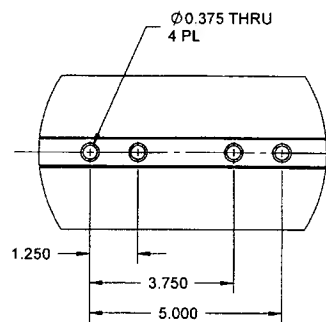
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

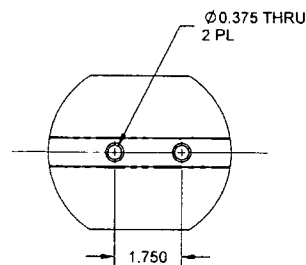
NOTE: Date & initial all entries



D3905-1 TUBE
(MAKE FROM D2500-1-190 EXTRUSION)



DETAIL A
SCALE 4X
D6-8
D2-8



DETAIL B
SCALE 4X
D5-8
D4-8

RELEASED
21/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3905	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 FLOAT SKIDTUBE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries